

SPLIT-2

DART AEROSPACE LTD	Work Order:	24009
Description: Saddle billet	Part Number:	D6101-005
Drawing: D6101 Rev. A	Qty:	100

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	U	05/08/12	100
2	PURCHASING	Issue P/O: <u>2008471</u> a) Description: Alluminum billet b) 5.00" x 8.250" x 2.50" thick c) Tolerance on all dimensions are +0.030"/-0.000" d) Grain direction along 5.00" length e) Material: 7075-T7351 (QQ-A-250/12) Material certification required	U	05/08/12	100
3	RECEIVING	Receive & Inspect for transit damage Ensure certification are attached	CL	06/02/06	50
4	QC	Inspect level 6 Check certification to Dwg D6101 for compliance	Inf	06/02/14	50
5	STORES	Identify & stock	CL	06/02/07	50
6	EXPEDITING	Close W/O Cost / part <u>5.44</u> 06/02/16 <u>50</u> Inspect Level 21	9	06/02/16	50

RF
03.06.05

Rev	Date	Change	Revised By	Approved
A	01.05.04	New Issue	EC	EC

RELEASED

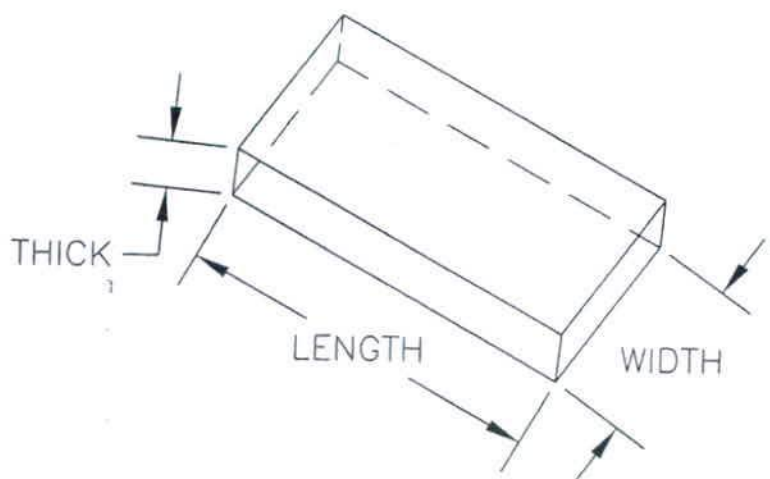
01.05.16





DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	JS	DRAWING NO.	Rev. A
DATE			D6101		SHEET 1 OF 1
01.03.30			TITLE		SCALE
A			SADDLE BILLET, 7075		NTS
01.03.30			NEW ISSUE		

SPECIFICATION CONTROL DRAWING



RELEASED
01.04.23

SHOP COPY
RETURNED
ENGINEER
UNCONTROLLED
SUBJECT TO
WITHOUT NOTICE
WORK ORDER
NO. 2406A

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 12, 2005
11:19 am

Work Order No	: 0024069	Department Code:	
Project Name	: D6101-005	Burden Flags	: NNNNNNNN
Project For	: WK540	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D6101-005	Invoice Number	:
Description	: 7075-T7351 8.25X5.0X2.5	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 100	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-12-05		
Est Finish Date	: 10-01-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

Labour Hrs/Amount Done	: Estimated	Actual
Profits/(Loss)	: 0.00	0.00
	: 0.00	0.00

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrabie

Mark J. Vrabie
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

573890	19028		
Ship Date	B.L. No.	Invoice No.	Alcoa No. Item
2006-01-20	02084	54800	DS-91531-1
P.O. No./Govt Contract No.	Customer		
CH1889	C&B-WALLINGFORD		

Page 1

Ship To: COPPER & BRASS SALES INC
WALLINGFORD BRANCH
5 STERLING DRIVE
WALLINGFORD, CT 06492

Item Description
2.500 IN TK X 60.5 IN W X 157.5 IN LN (N) A/T 7075-
T7351 RECTANGLE MILL FINISH, USI 3MM DEAD ZONE REQ'D BOTH SIDES,
SAWED {{ P/N 091557-9 }}. PER AMS-QQ-A-250/12 & EXCEPT MARKING AMS-
STD-2154 & EXCEPT MARKING MMS159 REV N &
EXCEPT MARKING ASTMB209 REV 04 & EXCEPT
MARKING BSS7055 REV A & EXCEPT MARKING
AMS4078 REV F USI PER PS21211 REV J MARKING PER
PS16120 REV G ULTRASONIC INSPECTION PE
ASTMB594 REV 02 ((MARKED)) INTERLEAVED MAX
GROSS SKID WGT: 5000 LB QUAN TOL +/-30 %
USI CL A 3 MM CQR 0162473 REV 01 CUST REQ 06-01-
01 *** W/E 06-01-07 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	367454	611671	2433	1	PC	
2	367470	611671	2424	1	PC	
3	367471	611671	2410	1	PC	
4	367484	611671	2432	1	PC	
			9699	4		

Notes for CQR: 0162473.1

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12. PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF MIL-STD-2154. THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.

CQR: 0162473.1 -Specification Limits -----

Tmpr	Dir	UTS	TYS	EL4D
		KSI	KSI	PCT
T7351	Long Transv.	Max	63.9	
		Min	66.0	52.0
T7351	Elec. Cond. (EC)	% MIN	38.0	PCT

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA

DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.
Per:

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

573890

Ship Date

2006-01-20

P.O. No./Govt Contract No.

CH1889

19028

B.L. No.

02084

Invoice No.

54800

Customer

C&B-WALLINGFORD

Ship From: RIVERDALE, IA.

Alcoa No. Item

DS-91531-1

Page 2

CQR: 0162473.1 -Specification Limits (cont.)

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other	
										Each	Total Aluminum
Alloy 7075	Max	.40	.50	2.0	.30	2.9	.28	6.1	.20	.05	.15
	Min			1.2		2.1	.18	5.1			REMAIN

Lot: 611671 -Mechanical, Physical, Metallography, Quantometer Results

Tmpr	Dir	No. Test		UTS KSI	TYS KSI	EL4D PCT
T7351	Long Transv.	3	Max	71.3	60.1	10.6
			Min	70.9	59.8	10.5
T7351	Elect Cond %IACS	40.0	40.1	40.2	PCT	

Cast Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
H9295041	Actuals	.07	.28	1.6	.03	2.5	.19	5.6	.02

COPPER AND BRASS SALES

MATERIAL TYPE

ALUMINUM ALLOYS WITH LOW BERYLLIUM

PRODUCT DESIGNATION

2014 2024 2224 2324 7050 7075 7150 7175 7475
ALUMEC 89 ALUMEC 99 QC-7

"WARNING"

SMALL CHIPS, FINE TURNINGS AND DUST MAY IGNITE READILY. EXPLOSION POTENTIAL MAY BE PRESENT WHEN: DUST OR FINES ARE DISPERSED IN THE AIR; FINE, DUST OR MOLTEN ALUMINUM ARE IN CONTACT WITH CERTAIN METAL OXIDES; OR, CHIPS, FINES, DUST OR MOLTEN ALUMINUM ARE IN CONTACT WITH WATER OR MOISTURE. KEEP AWAY FROM IGNITION SOURCE. USE EXPLOSION-PROOF VENTILATION. KEEP MATERIAL DRY.

THIS PRODUCT CONTAINS BERYLLIUM AND COPPER. INHALING BERYLLIUM DUST OR FUMES MAY CAUSE CHRONIC BERYLLIUM DISEASE (CBD), A SERIOUS CHRONIC LUNG DISEASE IN SOME INDIVIDUALS. BERYLLIUM IS A CANCER HAZARD; OVER TIME CBD AND CANCER CAN BE FATAL, TARGET ORGAN IS PRIMARILY THE LUNG. INHALING LARGE AMOUNTS OF COPPER, MAGNESIUM OXIDE, MANGANESE OXIDE, AND ZINC OXIDE FUMES OR DUST MAY CAUSE METAL FUME FEVER WITH FLU-LIKE SYMPTOMS. CHRONIC OVEREXPOSURE TO COPPER MAY CAUSE THICKENING OF THE SKIN; AND SKIN, TEETH, AND HAIR DISCOLORATION. CHRONIC OVEREXPOSURE TO MANGANESE DUST CAN CAUSE CENTRAL NERVOUS SYSTEM DAMAGE, SCARRING OF THE LUNGS AND REPRODUCTIVE HARM IN MALES. TARGET ORGAN IS PRIMARILY THE LUNG, BUT REPEATED HIGH EXPOSURE CAN ALSO AFFECT THE LIVER. CHRONIC OVEREXPOSURE TO IRON OXIDE DUST/FUME MAY CAUSE LUNG SIDEROSIS. CHRONIC OVEREXPOSURE TO SILICON DUST CAN CAUSE CHRONIC BRONCHITIS. OVEREXPOSURE TO AMORPHOUS SILICA CAN CAUSE DRYING OF THE MUCOUS MEMBRANES OF THE EYES, NOSE, AND THROAT.

THIS PRODUCT ALSO CONTAINS NICKEL AND CHROMIUM COMPOUNDS. INHALATION OF NICKEL DUST OR FUME MAY RESULT IN INFLAMMATION OF THE RESPIRATORY TRACT AND CAUSE NASAL AND/OR LUNG CANCER. NICKEL HAS BEEN IDENTIFIED AS A POTENTIAL HUMAN CARCINOGEN. EXPOSURE TO CHROMIUM DUST OR FUME MAY CAUSE METAL FUME FEVER WITH FLU-LIKE SYMPTOMS AND KIDNEY AND LIVER DAMAGE. UNDER HIGH TEMPERATURES, HEXAVALENT CHROMIUM MAY BE PRODUCED, IF IN THE INSOLUBLE FORM, IT IS A CONFIRMED HUMAN CARCINOGEN. (CALIFORNIA PROPOSITION 65).

IF COATED WITH OIL, MAY CAUSE SKIN IRRITATION/DERMATITIS BY CONTACT. WELDING FUME IS LISTED AS A POSSIBLE CARCINOGENIC TO HUMANS.

READ THE ALUMINUM/ALUMINUM ALLOYS MATERIAL SAFETY DATA SHEET(MSDS) ON FILE WITH YOUR EMPLOYER BEFORE WORKING WITH THIS MATERIAL

- * If processing or recycling produces particulate, use exhaust ventilation or other controls designed to prevent exposure to workers. Examples of such activities include melting, welding, grinding, abrasive sawing, sanding and polishing. Any activity which abrades the surface of this material can generate airborne particulate. Use respiratory protection (P100, quantitative fit testing required) if exposures exceed the permissible limits.
- * The Occupational Safety and Health Administration (OSHA) have set mandatory limits on occupational exposures.
- * Aluminum, in solid form and as contained in finished products presents no special health risk.
- * Sold for manufacturing purposes only. This product can be recycled; contact your sales representative.

The Occupational Safety and Health Administration require employers to provide training in the proper use of this product.

For additional information, call or write to Copper and Brass Sales, 22355 West Eleven Mile Road, Southfield, MI 48034, telephone 248-233-5600, or visit our web site @ www.copperandbrass.com.

